



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D119-796-251
Job Sheet 190030



Part No: D119-796-251

Job Qty: 1 pcs

Part Name: Aft Crosstube Installation With Step (No Hardware)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/4/19

Job Tracking No:

Due Date: 4/5/19

Created By: Jesse White

Type: Stock

Description:

Note: DWG D119-796-251 REV E, IIN-D119-796 REV F IPP REV:A 14.09.09 NEW ISSUE DD VERF:JLM IPP
REV:B 14.10.15 AS PER REV.A DD VERF:JLM IPP REV:C 14.11.19 AS PER REV.C DD VERF:JLM IPP
REV:D 14.12.09 AS PER REV.PC6 DD VERF:JLM IPP REV:E 15.02.11 AS PER REV D JLM VERF:DD IPP
REV:F 17.12.11 REMOVE PACK KIT DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
130	Crosstubes - 1	1 pcs	4/5/19		0.00	0.51	Crosstubes - 1		
							Crosstubes - 2		
							Crosstubes - 3		
							Crosstubes - 4		148 19-6-30
140	QC 5	1 pcs	4/5/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
142	Packaging 1-1 - Pick Kit - B4B	1 pcs	4/5/19		0.00	0.00	Packaging 1 - 1 - B4B		NR
							Packaging 1 - 2 - B4B		
							Packaging 1 - 3 - B4B		
							Packaging 1 - 4 - B4B		
							Packaging 1 - 5 - B4B		
							Packaging 1 - 6 - B4B		
							Packaging 1 - 7 - B4B		
							Packaging 1 - 8 - B4B		



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Container No: S196030



Part: D119-796-251

Job No: 190030

Serial No/Batch: S196030

Revision: F/G

Inspector:

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					Packaging 1 - 9 - B4B	
					Packaging 1 - 10 - B4B	
					Packaging 1 - 11 - B4B	
					Packaging 1 - 12 - B4B	
					Packaging 1 - 13 - B4B	
					Packaging 1 - 14 - B4B	
					Packaging 1 - 15 - B4B	
					Packaging 1 - 16 - B4B	
					Packaging 1 - 17 - B4B	
					Packaging 1 - 18 - B4B	
					Packaging 1 - 19 - B4B	
					Packaging 1 - 20 - B4B	
					Packaging 1 - 21 - B4B	
					Packaging 1 - 22 - B4B	
					Packaging 1 - 23 - B4B	
					Packaging 1 - 24 - B4B	
					Packaging 1 - 25 - B4B	
					Packaging 1 - 26 - B4B	
					Packaging 1 - 27 - B4B	
					Packaging 1 - 28 - B4B	
					Packaging 1 - 29 - B4B	
					Packaging 1 - 30 - B4B	
					Packaging 1 - 31 - B4B	
					Packaging 1 - 32 - B4B	
					Packaging 1 - 33 - B4B	
					Packaging 1 - 34 - B4B	
					Packaging 1 - 35 - B4B	
					Packaging 1 - 36 - B4B	
143	QC 4	1 pcs	4/5/19	0.00 0.00	QC 4 - 28	NR
					QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
145	DC - 1 - B4B	1 pcs	4/5/19	0.00 0.00	DC - 1 - B4B	DAG NR
					DC - 2 - B4B	21 JUL 09 2019
150	Packaging 3-1 - Stock - B4B	1 pcs	4/5/19	0.00 0.00	Packaging 3 - 1 - B4B	2-85
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	AP 19-7-9
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Plex 4/8/19 12:55 PM Dart.Hadley.Shannon	

				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - FG	1 pcs	4/5/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	DAS 21 JUL 09 2019
				QC 21 - FG - 53	
Part Op 130 - 1- Install step and clamp with the proper position per dwg D119-796-251 ***Torque all clamps to 50 IN-LBS max.*** Descriptions: 140 - (QC5- Inspect part completeness to step on W/O) ***RE-CHECK TORCQUE ON CLAMP AS PER DWG.*** 142 - (Pick Kit) 143 - (QC4- 100% Inspect kits for completeness) 145 - Photocopy bluefile and create labels as per PPP D119-796-251 chg 004 150 - (Identify as per dwg & Stock Location: <u>LG050</u>) Identify and pack for shipping as per PPP D119-796-251 160 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D119-796-241	Aft Crosstube Installation Without Step (No Hardware)	1 pcs (1 ea)	130-Crosstubes - 1		
D5149-043	Aft Step Base Assembly	2 pcs (2 ea)	130-Crosstubes - 1		
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
130-Crosstubes - 1	D119-796-241 <u>194137</u>	① 5177494	1	0	
	D5149-043 <u>5177721</u>	② 5171576①	2	0	
Part Specifications					
Specifications could not be found.					

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Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/5/19	0.00	0.00	Start Up Crosstubes-1		
130	Crosstubes	1 pcs		4/5/19	0.00	0.51	Crosstubes-1		
140	QC	1 pcs		4/5/19	0.00	0.00	QC5		
142	Packaging	1 pcs		4/5/19	0.00	0.00	Packaging1-6		
143	QC	1 pcs		4/5/19	0.00	0.00	QC4		
145	DC	1 pcs		4/5/19	0.00	0.00	DC		
150	Packaging	1 pcs		4/5/19	0.00	0.00	Packaging3-1		
160	QC21-FG	1 Ea		4/5/19	0.00	0.00	QC21		

Part Op 130 - 1- Install step and clamp with the proper position per dwg D119-796-251 ***Torque all clamps to 50. IN-LBS max.***

Descriptions: 140 - ***RE-CHECK TORCQUE ON CLAMP AS PER DWG.***

145 - Photocopy bluefile and create labels as per PPP D119-796-251 chg 004

150 - Identify and pack for shipping as per PPP D119-796-251

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D119-796-241	Aft Crosstube Installation Without Step (No Hardware)	1 pcs (1 ea)	90-Start up Operation	
D5123-3	Clamp Cushion	4 pcs (4 ea)	90-Start up Operation	
D5149-043	Aft Step Base Assembly	2 Ea (2 ea)	90-Start up Operation	
MS21920-25	Clamp	4 Ea (4 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D119-796-241	1	0	0
	D5123-3	4	205	0
	D5149-043	2	0	0
	MS21920-25	4	161	0

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :		Sequence #:		QTY Affected :		MRB (QSI042)	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
		Other/Details:					